

Date: Thursday, 27/11/2008 2:36:52 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 43825  
 Estimate Number : 10317  
 P.O. Number :  
 This Issue : 27/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 34724  
 Drawing Name : BEARPAW KIT (13"X16")  
 Part Number : D206559021  
 Drawing Number : D2671 REVB1  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 04/12/2008 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.11.27  
 Comment :  
 Est Rev:C 04.02.17 Blank size changed KJ/JLM  
 Est Rev:D 07-01-02 Was K10005 JLM  
 Est Rev:E 08-01-09 Added Step 2 JLM Verified  
 By:EC  
 Est Rev:F 08-05-05 up a chg DD verified by:EC  
 Est Rev:G New Manufacturing Method 08-10-29 JLM Verified  
 By:EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



*JLD 08/12/03*



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-021 CHG007

*5 09/01/07*

2.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Program Batch Number

*JLD 08.11.27*

3.0

MUHMB10

UHMW 1" Black



Comment: Qty.: 3.0500 sf(s)/Unit Total: 6.1000 sf(s)

blank:

Material: Black UHMW 1"

(MUHMB10)

Batch: *109186* *B 8-12-2*

④

4.0

WATER JET

FLOW WATER JET



Comment:

FLOW WATER JET

Cut Blank as per File D2671\_BLANK

*B 8-12-2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 43825

Part Number: D206559021

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

(4)

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671

3-Deburr

M.A 09/01/09

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/01/09

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/01/11 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6700 f(s)/Unit Total: 3.3400 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

B42737

SD

10.0

D2274

Radius Block



2x

Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2671(ref only) Bearpaw

B42099

B43828

9/1/12

SD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 43825

Part Number: D206559021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2438	Clamp
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp B341428

12.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer B342408

13.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M109148

14.0	AN417A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-17A Bolt M109061

15.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer M109249

8/6/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:	Machine Or Operation:	Description :
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16.0	MS21042L4	Nut
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M108145

17.0	QS200M44S	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S Clamp M105516

1 Paperwork package

18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-021

Location: B

20.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43825
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2671
<b>Inspection Dwg:</b> D2671	<b>Rev:</b> B1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053x45°	✓			
B	5.500	+/-0.030	5.499	✓			
C	0.200	+/-0.030	0.203	✓			
D	R0.250	+/-0.030	R0.250	✓			
E	0.625	+/-0.030	0.627	✓			
F	0.250	+/-0.010	0.251	✓			
G	0.950	+0.030/-0.010	0.956	✓			
H	0.25 x 45°	+/-0.030	0.254	✓			
I	0.375	+/-0.010	0.375	✓			
J	12.750	+/-0.030	12.750	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.93	+/-0.030	Ø0.925	✓			
M	0.30	+0.030/-0.000	0.310	✓			
N	4.250	+/-0.030	4.251	✓			
O	0.375	+/-0.030	0.375	✓			
P	2.000	+/-0.030	1.997	✓			
Q	4.250	+/-0.010	4.250	✓			
R	9.000	+/-0.010	8.995	✓			
S	15.750	+/-0.030	15.750	✓			

<b>Measured by:</b> H.A	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/01/09	<b>Date:</b> 09/01/11	<b>Date:</b>

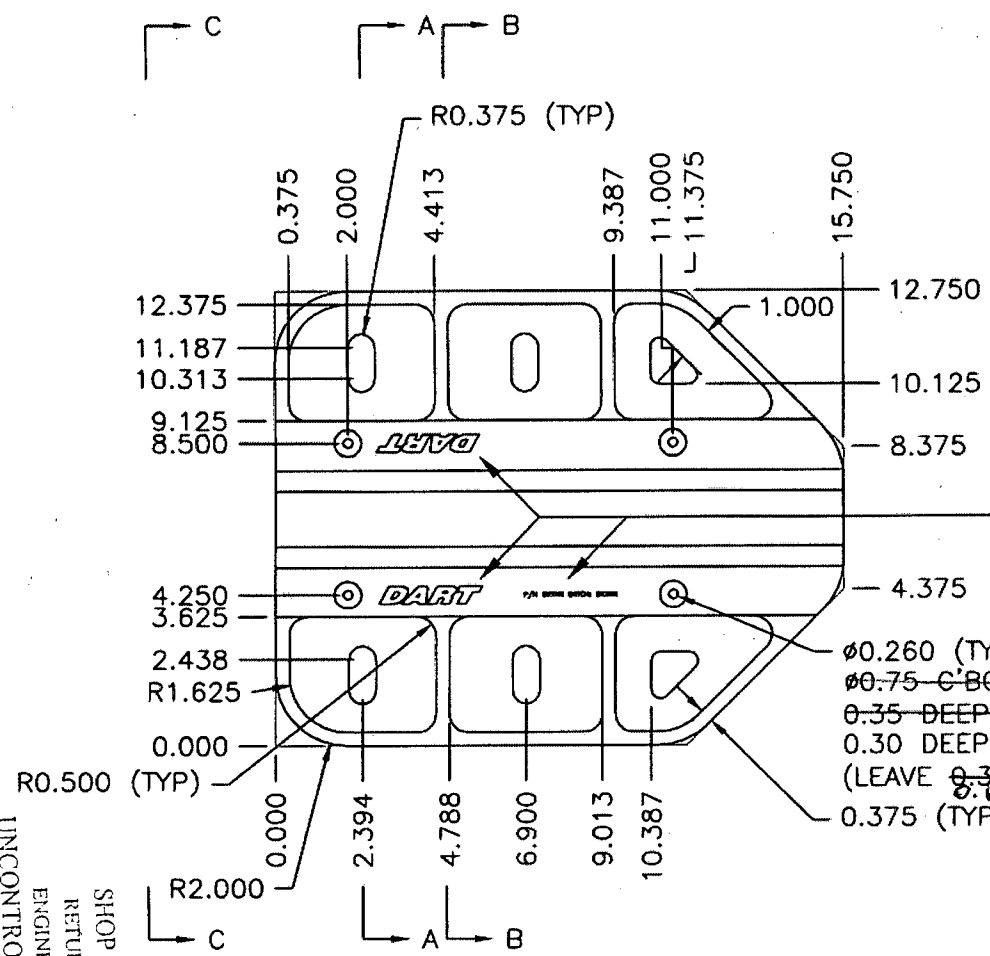
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

B1 02.12.17  $\phi 0.93$  WAS  $\phi 0.75$



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2671	REV. B
DATE 98.05.19		TITLE BEARPAW	SHEET 1 OF 2
			SCALE 1:5
A	97.04.08	NEW ISSUE	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

RELEASED  
99.06.17 KE



EFFECTIVE	DEOS
9143	

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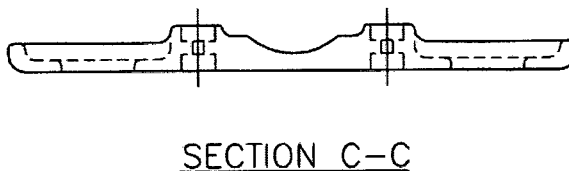
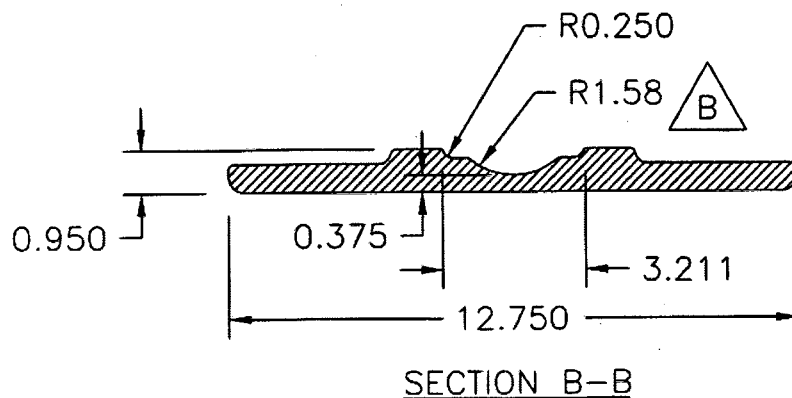
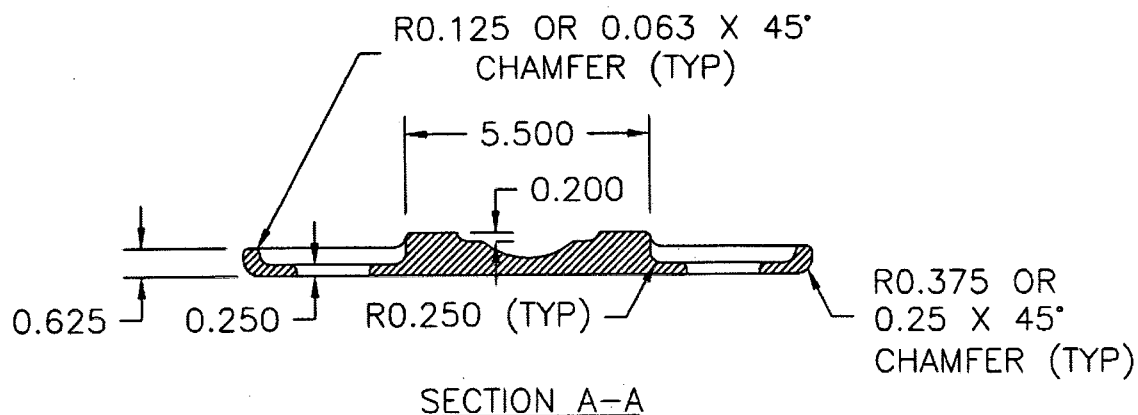
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WORK ORDER  
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 *KE*



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